

# Work Order ID 67188

Wednesday, March 09, 2011 2:33:28 PM



Page 1

Item ID: D2989-043

Accept



Setup Start



Revision ID:

Item Name: Basket Lid Assembly

Stop



Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*Handwritten signature*

Date: 11-03-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2989

Rev D

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989  
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig  
3- to locate hinges and shims use D2989-041, weld as per dwg D2989  
A/R ER316 S.S. Rod Batch: M114649

*Handwritten signature* 11.03.17 (X)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*Handwritten signature* 11.03.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67188**

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Page 2

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Start Date: 3/9/2011 Start Qty: 1.00



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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

QC6- Inspect dimensions to drawing

0.00

S 11/03/11

Memo

0.00

Quality Control

125



HandFinish

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

Hand Finishing

1 BL 11-3-28

W/O:		WORK ORDER CHANGES					
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**Item ID:** D2989-043

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress regularly to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves comparing the actual outcomes against the objectives and goals to determine the effectiveness of the project.

**Setup Start**

**Stop**

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<[illegible]

**Required Date:** 3/18/2011      **Req'd Qty:** 1.00

**Reference:**

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

Memo

0.00

**Powdercoat**

## Powder Coating

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

140

QC3- Inspect Part Finish

0.00

\_\_\_\_\_

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Identify as per dwg & Stock Location: W/U

0.00



0356-607-043/ B67184

Packaging

Memo

0.00

x1 φ 11/03/25

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Q 11/03/29  
MF

11-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries






Tuesday, March 15, 2011 7:19:55 AM

**Parent Item Name:** Basket Lid Assembly

**Required Date:** 3/18/2011

**Required Qty: 1.00**

**Comments:** IPP Rev:I Removed D2989-041 05-11-03 JLM  
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC  
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC  
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1  Rib		Manufactured	No			100	Each	6.0000	1	1		11.03.15	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA006				6					
				63628				1					
				64651				5					
✓ D2989-3  Rib		Manufactured	No			100	Each	6.0000	1	1		11.03.15	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				6					
				59006				1					
				59034				1					
				64584				2					
				66917				2					
✓ D2989-4  Rib		Manufactured	No			100	Each	4.0000	1	1		11.03.15	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA005				4					
				64583				2					
				66916				2					

# Picklist Print

Tuesday, March 15, 2011 7:19:56 AM

Page 2

Work Order ID: 67188

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D2989-5      Manufactured      No      100      Each      6.0000      2      2  
Rib  
11.03.15

Location	Loc Qty	Loc Code
WA005	6	
64369	2	
66915	4	

✓ D3182-1      Manufactured      No      100      Each      10.0000      2      2  
Hinge  
11.03.15

Location	Loc Qty	Loc Code
WA005	10	
61395	2	
64370	2	
65486	6	

✓ D3442-3      Manufactured      No      100      Each      16.0000      2      2  
Shim  
11.03.15

Location	Loc Qty	Loc Code
WA005	16	
61756	2	
63877	5	
66912	9	

✓ D3827-041      Manufactured      No      100      Each      7.0000      1      1  
Rib Assembly (Inboard)

Location	Loc Qty	Loc Code
WA006	7	
64857	1	
65485	6	

Tuesday, March 15, 2011 7:19:56 AM

Shop Packet Print

Page 2

# Picklist Print

Tuesday, March 15, 2011 7:19:57 AM

Page 3

Work Order ID: 67188

Parent Item: D2989-043



Parent Item Name: Basket Lid Assembly

Start Date: 3/9/2011


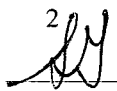
Required Date: 3/18/2011

Start Qty: 1.00


Required Qty: 1.00

✓ D3832-5 Manufactured No 100 Each 4.0000 1 1  
  
 Mesh (Lid)  11.03.15


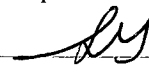
Location	Loc Qty	Loc Code
WA	4	
63233	1	
64368	3	

✓ D3833-5 Manufactured No 100 Each 13.0000 2 2  
  
 Mesh (Lid End)  11.03.15

Location	Loc Qty	Loc Code
WA	13	
53722	1	
61317	2	
63055	2	
63665	2	
64946	6	

✓ D3838-041 Manufactured No 100 Each 2.0000 1 1  
  
 Rib Assembly (Basket Lid, LH)  11.03.15

Location	Loc Qty	Loc Code
WA005	2	
64860	2	

✓ D3838-042 Manufactured No 100 Each 2.0000 1 1  
  
 Rib Assembly (Basket Lid, RH)  11.03.15

Location	Loc Qty	Loc Code
WA005	2	
64861	2	

Tuesday, March 15, 2011 7:19:57 AM

Shop Packet Print

Page 3

**D2989-043 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

**D2989-041 BASKET LID ASSEMBLY**  
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4  
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
  - 8) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 67188  
PL 11-03-9

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED  
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-11/-21/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN			
CHECKED	AJS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2989</b> TITLE <b>BASKET LID ASSEMBLY</b> REV. D SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

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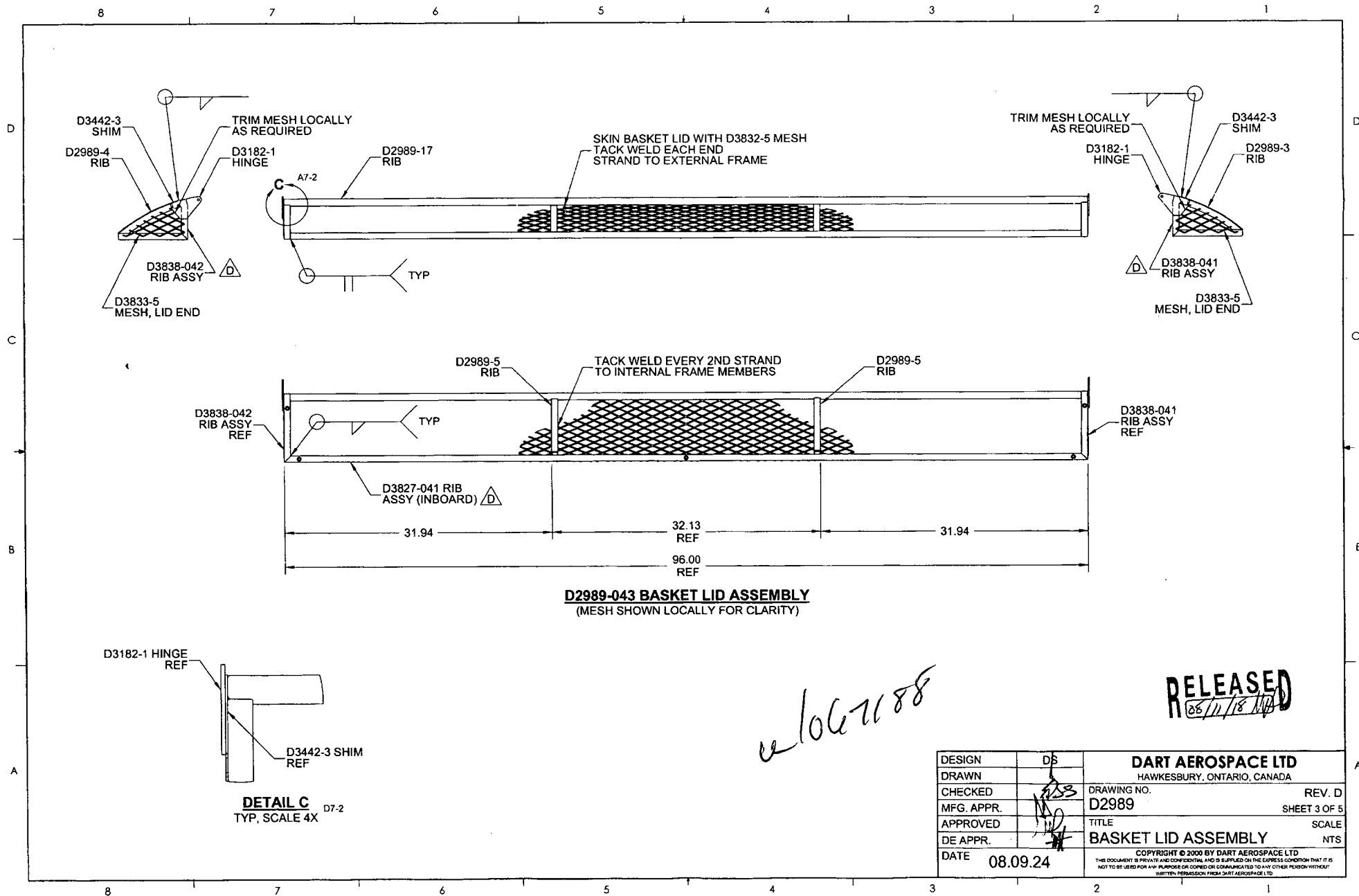
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DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	DS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO. <b>D2989</b>	REV. D
MFG. APPR.	DS	SHEET 3 OF 5	
APPROVED	DS	TITLE <b>BASKET LID ASSEMBLY</b>	SCALE NTS
DE APPR.	DS	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	08.09.24	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



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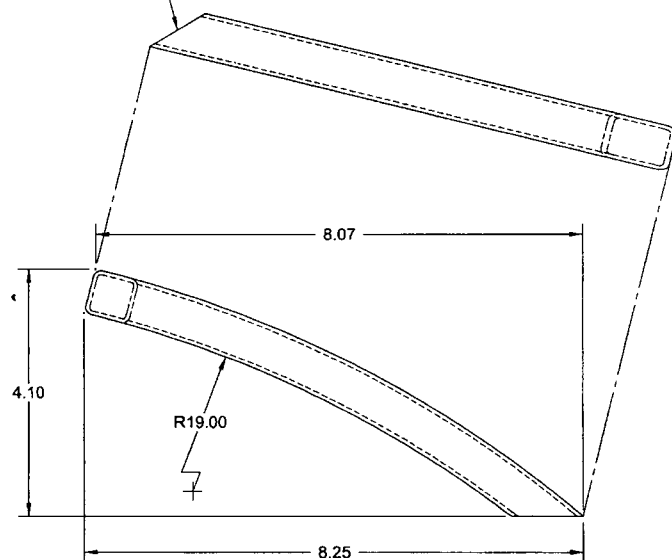
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

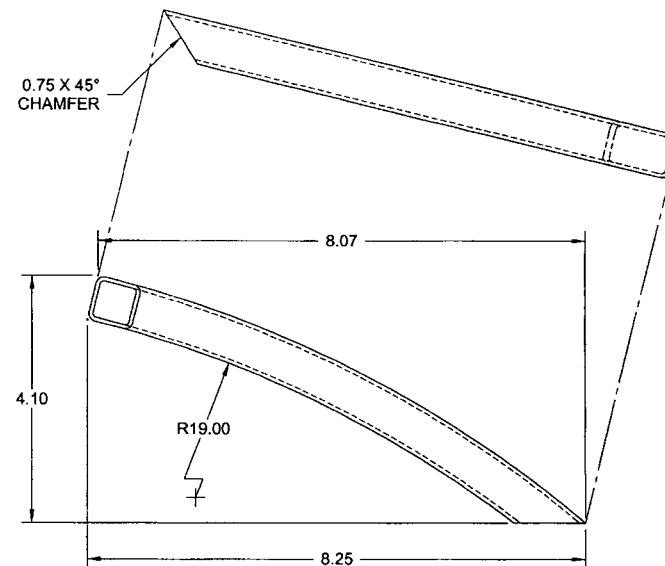
**NOTE:** Date & initial all entries

0.75 X 45°  
CHAMFER

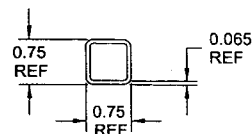


**D2989-3 RIB**

0.75 X 45°  
CHAMFER



**D2989-4 RIB**



**TYPICAL SECTION  
VIEW**

**NOTES:**

- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

*also 60185*

**RELEASED**  
*08/11/18*

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D2989</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID ASSEMBLY</b>	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

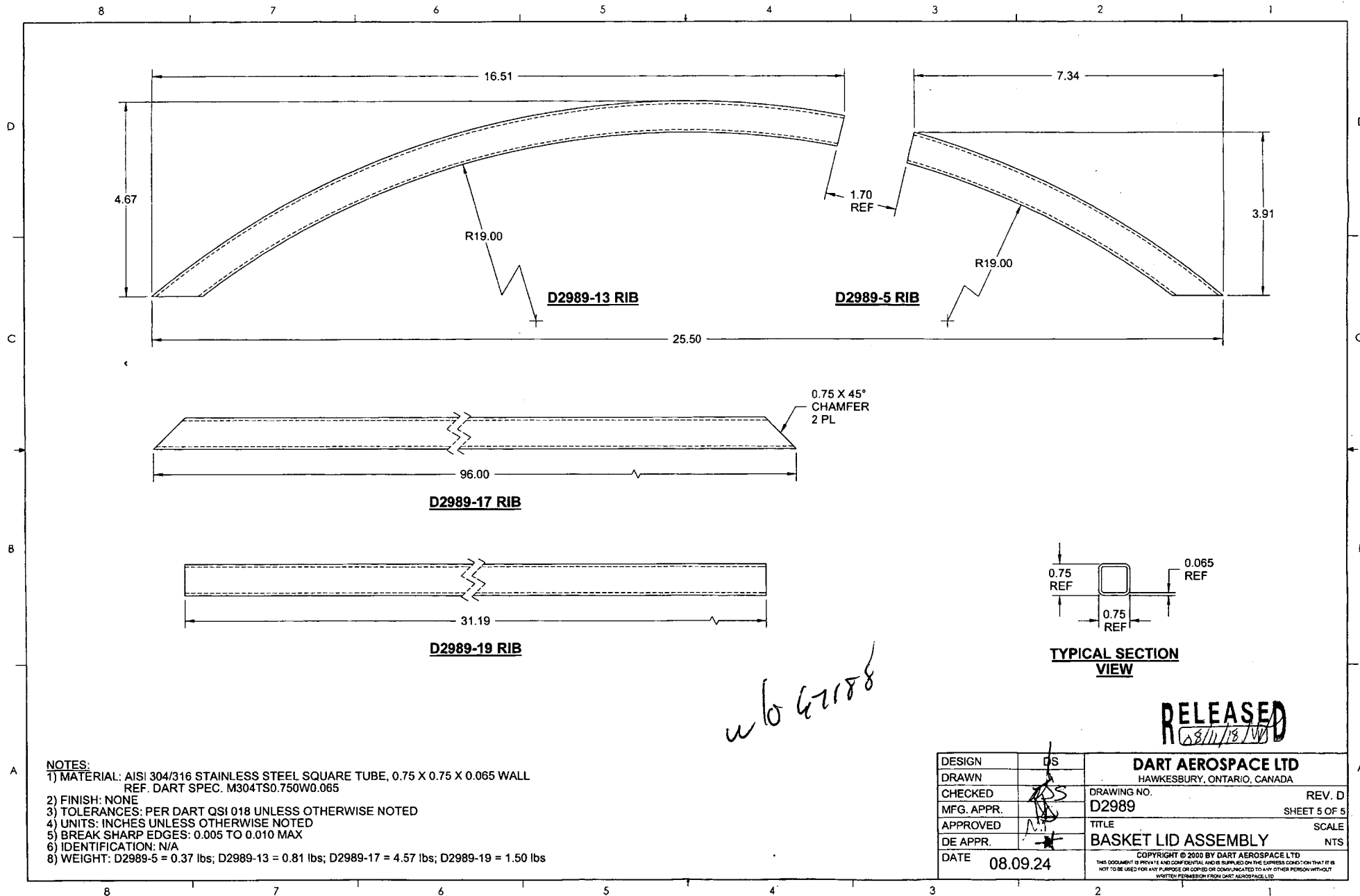
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries